

Date: Friday, 9/1/2006 12:07:03 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 28390		
Estimate Number	: 10609		
P.O. Number	: N/A	Part Number	: D33195
This Issue	: 9/1/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3319 REV. B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 23342	Drawing Revision	: B
	Type : SMALL /MED FAB	Material	: N/A
Written By	: <u> </u>	Due Date	: 9/19/2006
Checked & Approved By	: <u> </u>	Qty:	12 Um: Each
Comment	: Est: A 05.05.11 New issue KJ/JLM Est Rev:B Now On Waterjet 06-08-15 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S18GA	1010/1025/A21/6aA SHEET .048
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Comment: Qty.: 0.6888 sf(s)/Unit Total : 8.2656 sf(s)
1010/1025 SHEET 18 GAUGE (.048" thk)
(M1010S18GA)
Batch: M101926

MA 06 09 05

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3319
Dwg Rev: B
Prog Rev: B

MA 06 09 05

(12)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MA 06 09 05

(12)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

MA 06 09 06

(12)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary

SAO 06:09:16

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/1/2006 12:07:04 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 28390

Part Number: D33195

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

SB 06/09/20

(52)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

June 25

(12)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3319-5T2 per QSI 004 and Dwg D3319 Rev: B

(12)

Qty Part Number Description Batch

A/R N/A 7560 Hardcoat Rod

M 10/217

Pl 06-10-10

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Pl 06-10-10

(12)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 06 10 12 12

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

ml 06/10/13

(12)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-5, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: 57362

with labels fabrication strip

u

ml 06/10/13

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/10/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/1/2006 12:07:04 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 28390

Part Number: D33195

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

12 06/10/16

Job Completion



12 06/10/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

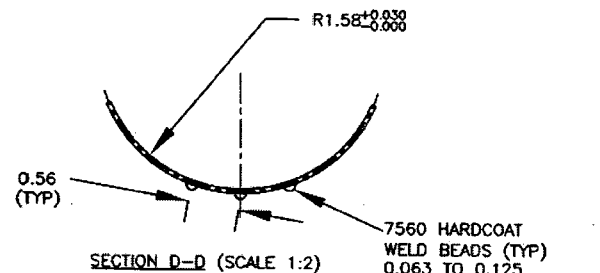
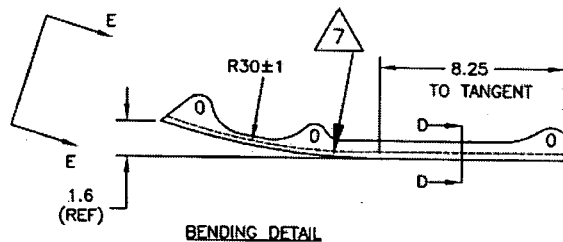
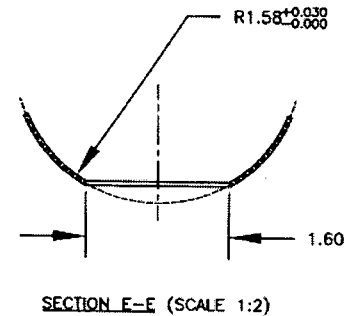
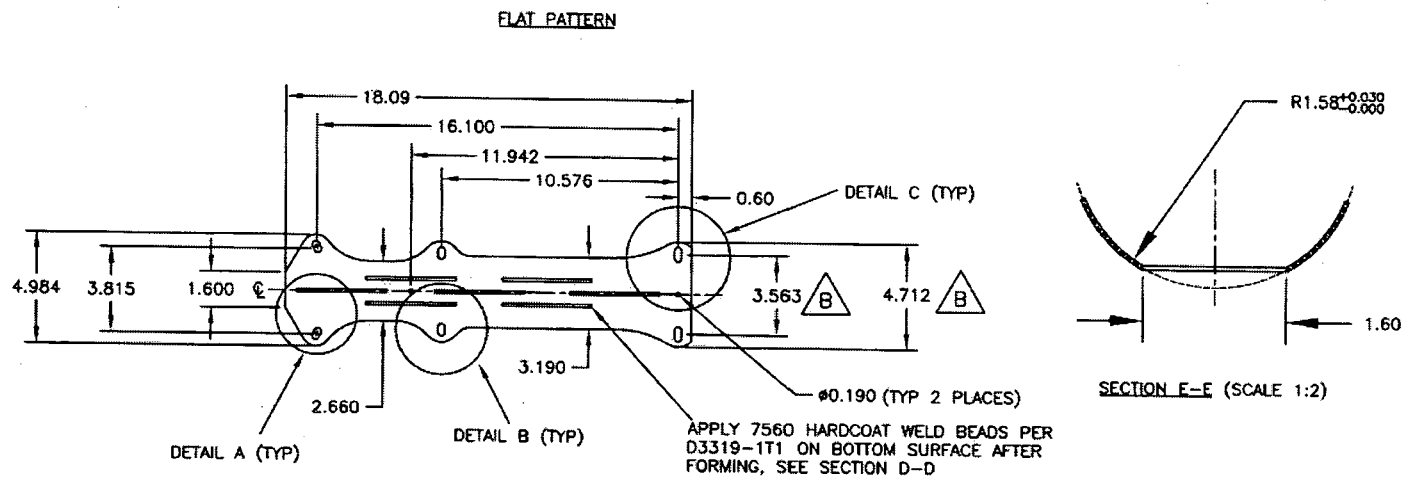
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

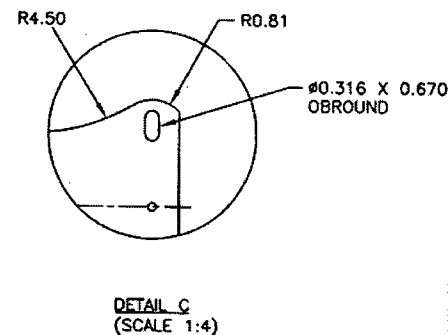
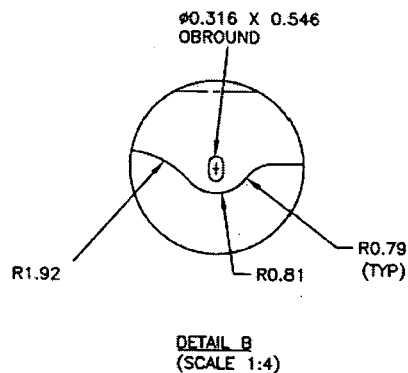
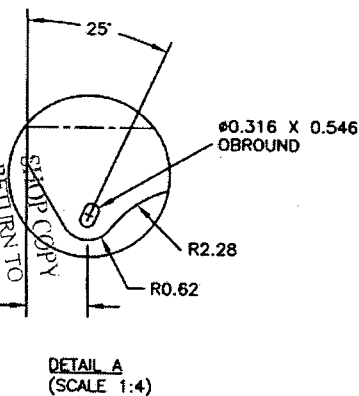
DART



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05-09-30

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WORK ORDER
28390



D3319-1 WEARPLATE

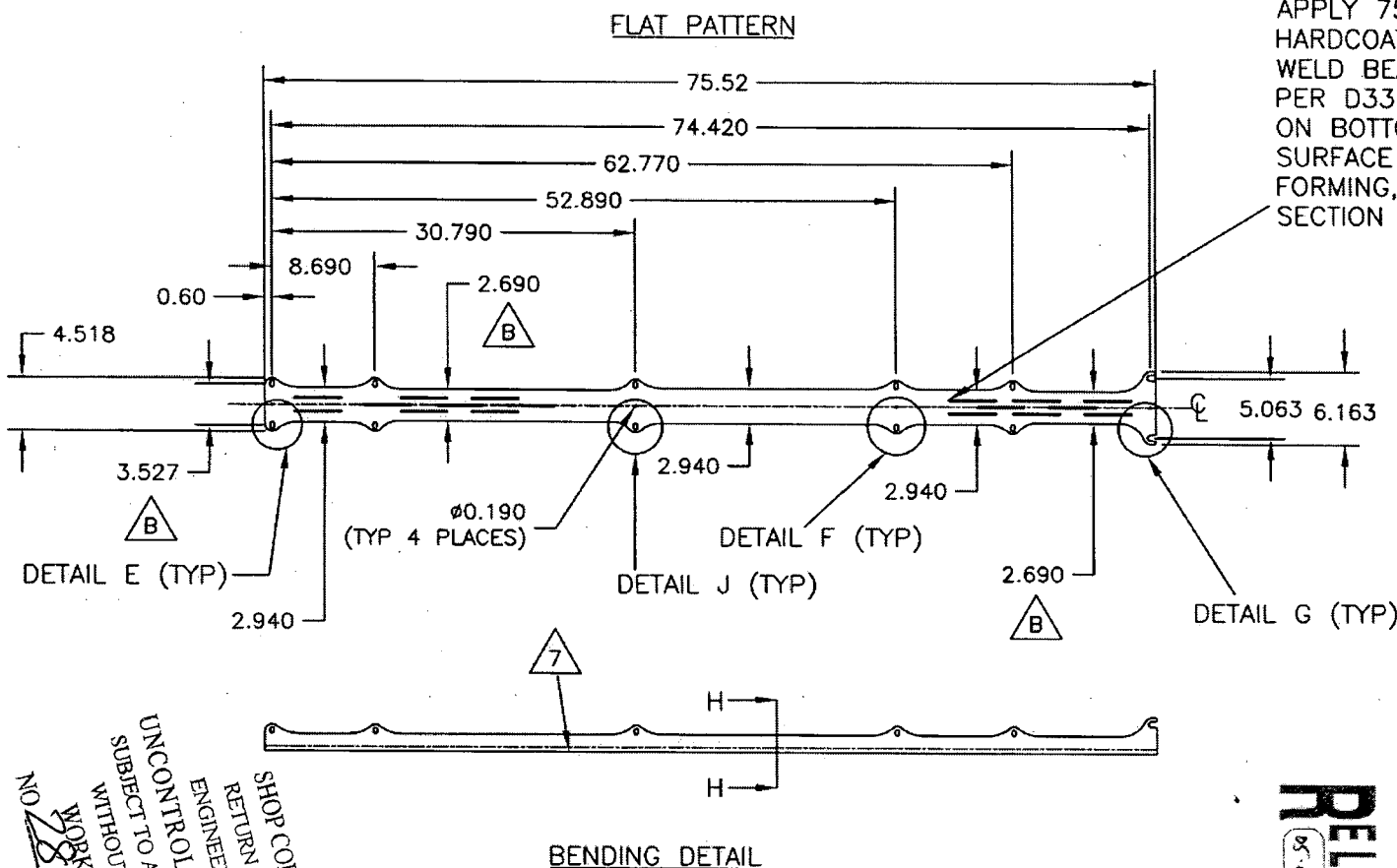
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>PH</i>	APPROVED <i>PH</i>	HAWKESBURY, ONTARIO, CANADA
DATE 05.06.06	TITLE WEARPLATE	REV. B
	DRAWING NO. D3319	SHEET 1 OF 5
	DATE 04.09.24	SCALE 1:8
	05.06.06	
	NEW ISSUE	
	WIDEN HOLES, REDUCE WIDTH -3/-5/-7	

DART

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DATE 05.06.06	TITLE	REV. B
	DRAWING NO. D3319	SHEET 2 OF 5
	WEARPLATE	SCALE 1:15

APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H



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WORK ORDER
NO 28390

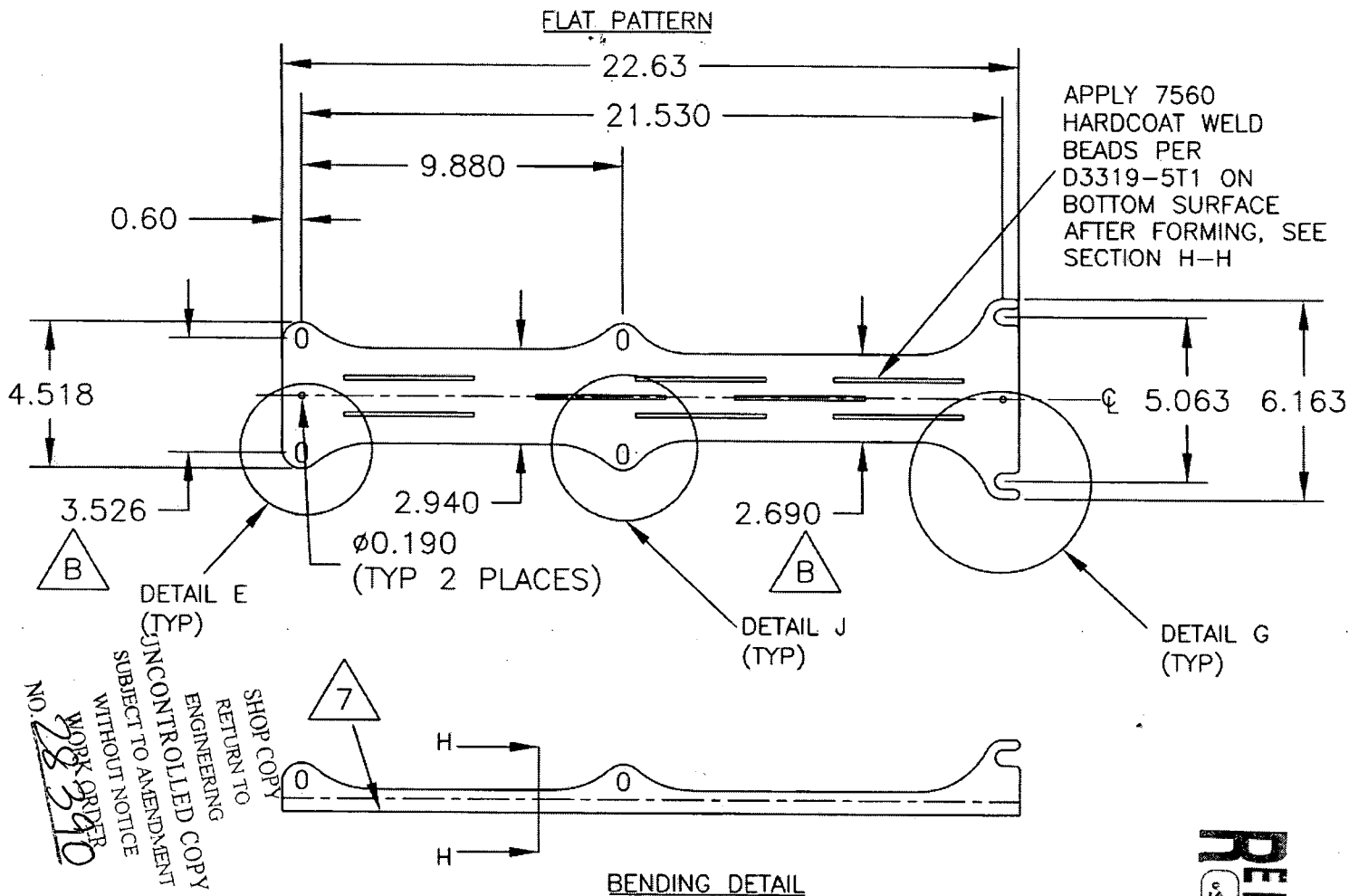
D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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05.07.30

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CHECKED <i>PH</i>	APPROVED <i>PH</i>	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
05.06.06	D3319	SHEET 3 OF 5
	TITLE	SCALE
	WEARPLATE	1:5

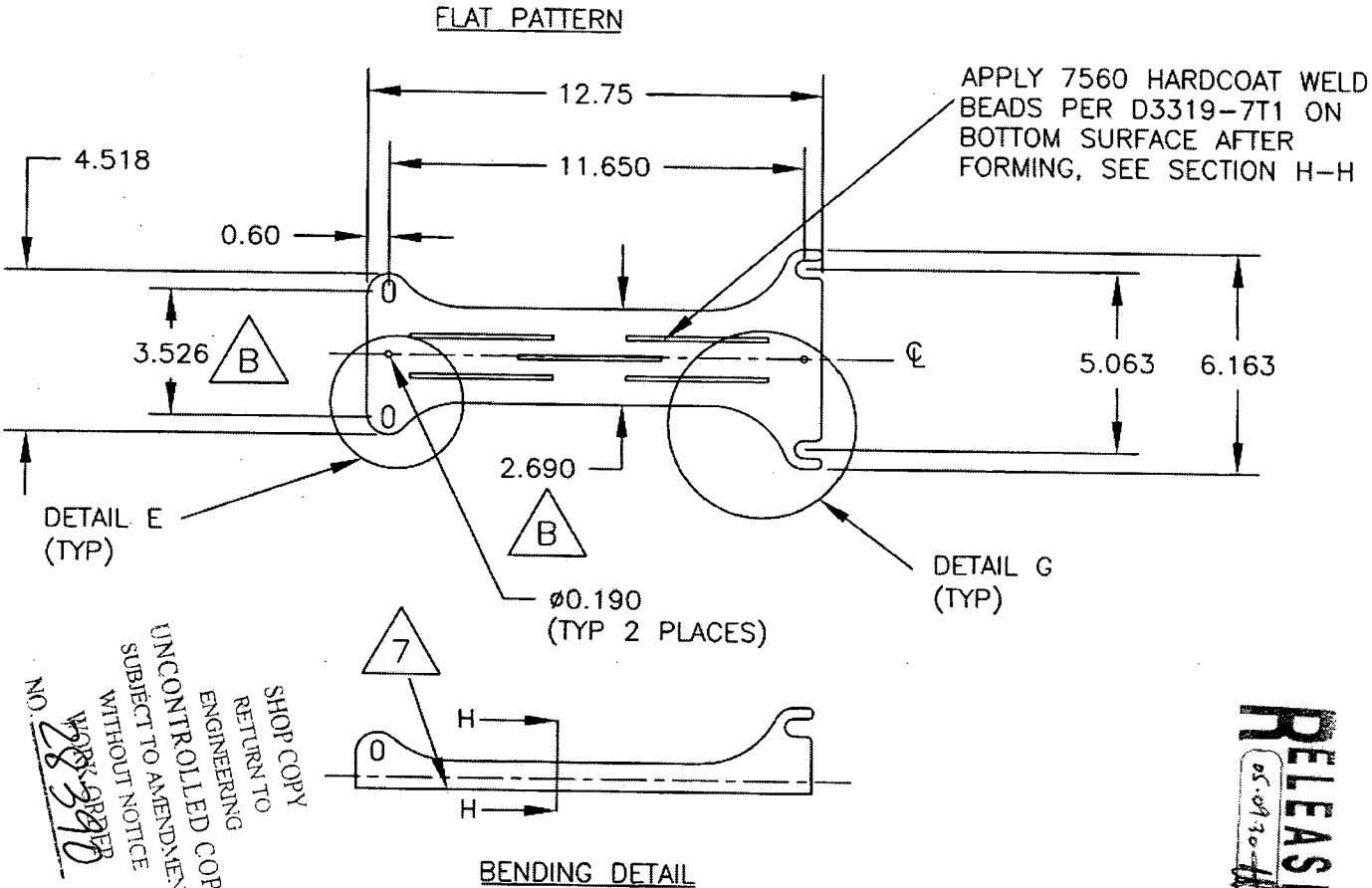
**D3319-5 WEARPLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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CHECKED CH	APPROVED CH	DRAWING NO. D3319	REV. B SHEET 4 OF 5
DATE 05.06.06	TITLE WEARPLATE		SCALE 1:5



05-0930-11

D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
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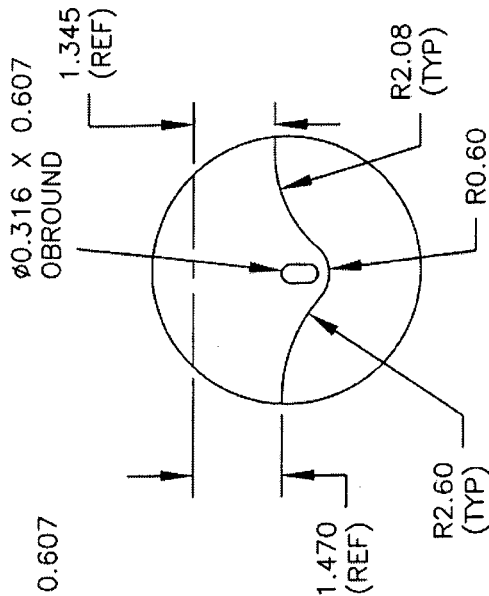
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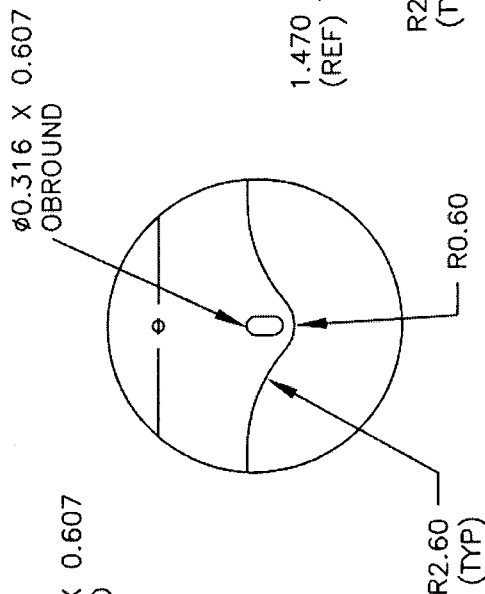


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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06	TITLE WEARPLATE		SCALE 1:3

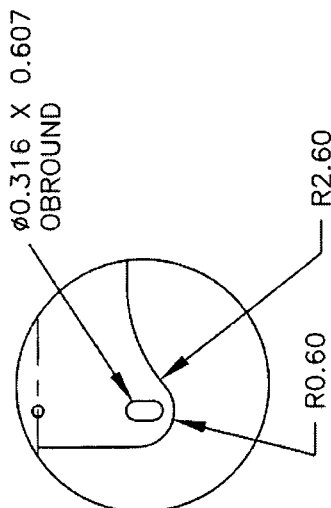
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05 09 30



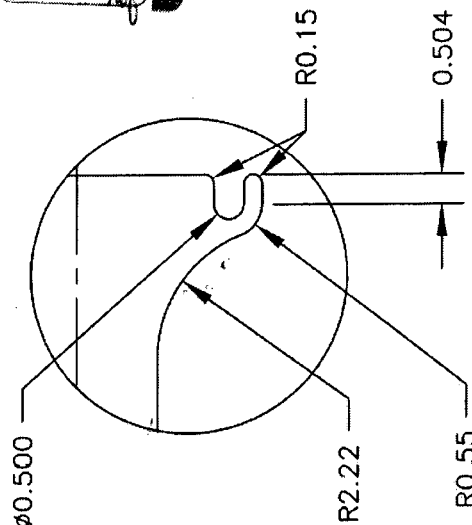
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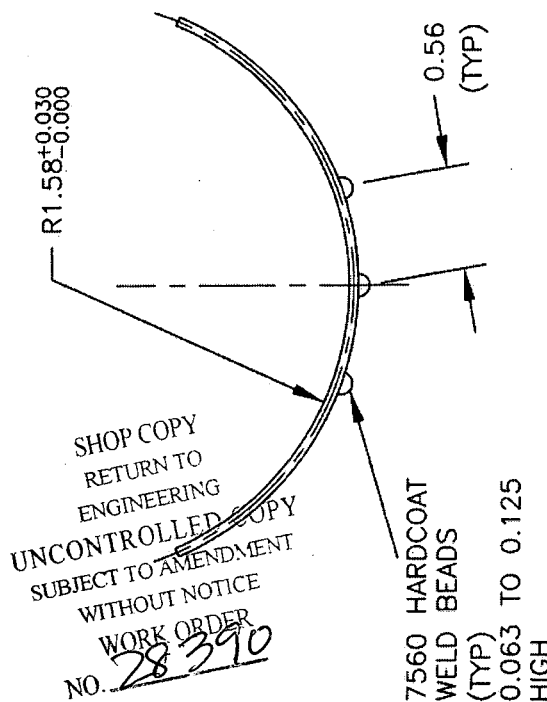
DETAIL I



DETAIL E



DETAIL G



SECTION H-H
(SCALE 1:1)

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